

Work Order ID 105590

August-08-13 10:03:01 AM

ASAP Aug 15 best
105590

Page 1

Item ID: D3171-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Angle Bracket

Start Date: 8/08/13 Start Qty: 20.00

20

Cust Item ID:

Required Date: 8/16/13 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan:

✓

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3171	Rev A
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100	
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100	FLOW WATER JET
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Waterjet	Memo
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FLOW CNC Waterjet	1-Cut as per Dwg D3171 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-
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304-063	Deburr if necessary
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110	QC2- Inspect parts off machine FAI/FAIB
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110	Memo
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QC	0.00
----	------

Quality Control	
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120	QC8- Inspect parts - second check
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120	Memo
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QC	0.00
----	------

Quality Control	
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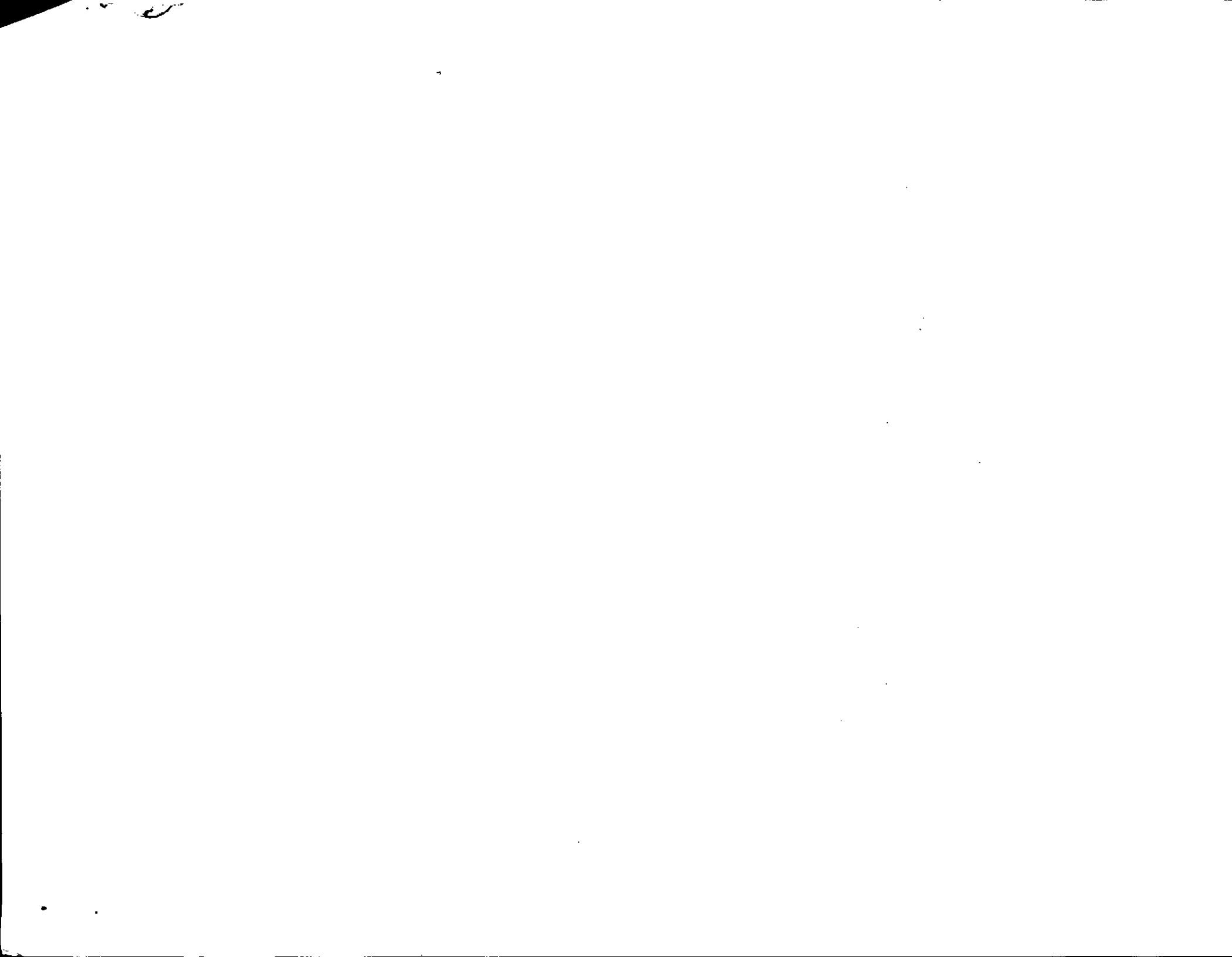
DAS
16
9-09

B6869

(out)

Y23

Jm, 3-08-09



22

Work Order ID 105590

105590

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August-08-13 10:03:01 AM

Item ID: D3171-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Angle Bracket

Start Date: 8/08/13 Start Qty: 20.00

20

Cust Item ID:

Required Date: 8/16/13 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: ST

0.00

160

Packaging

Packaging

PPP: 6x ship

0.00

23X 11.13-08-12

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

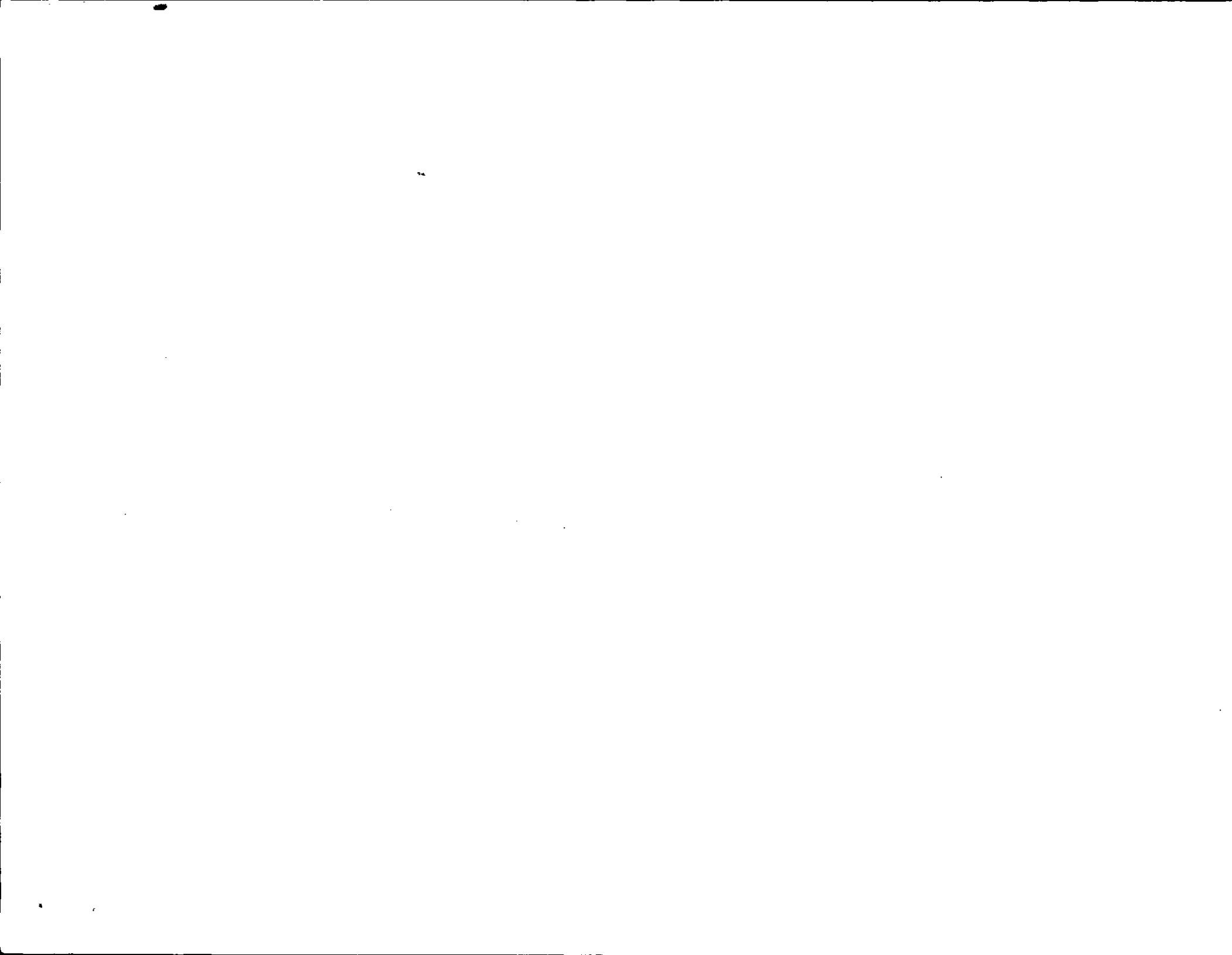
Quality Control

Memo

0.00

MLJ 13-08-12

MLJ 13-08-12



Picklist Print

August-08-13 10:03:01 AM

Page 1

Work Order ID: 105590

Parent Item: D3171-1

Parent Item Name: Angle Bracket

Start Date: 8/08/13

Required Date: 8/16/13

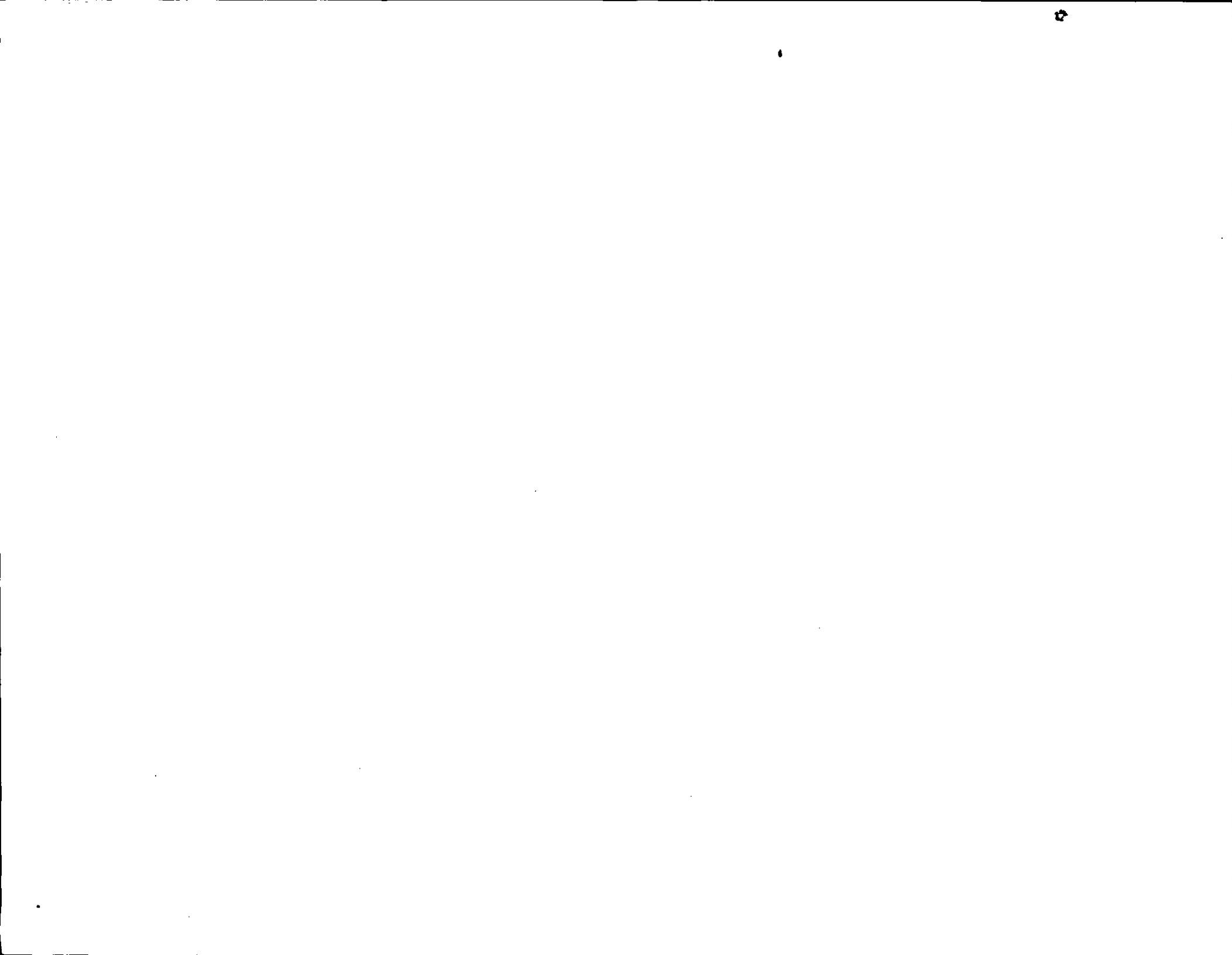
Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A02.11.04New IssueKJ
IPP Rev:B 08-03-27 now on water jet DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	345.5802	0.0206	6.9336842 8.5		JN 13-08-07	

Location	Loc Qty	Loc Code
MAT020	345.5801686	
I22245	0.1713688	
I23136	140.8	
I24428	23.61	
I25599	5.410631	
M126159	175.588169	126159



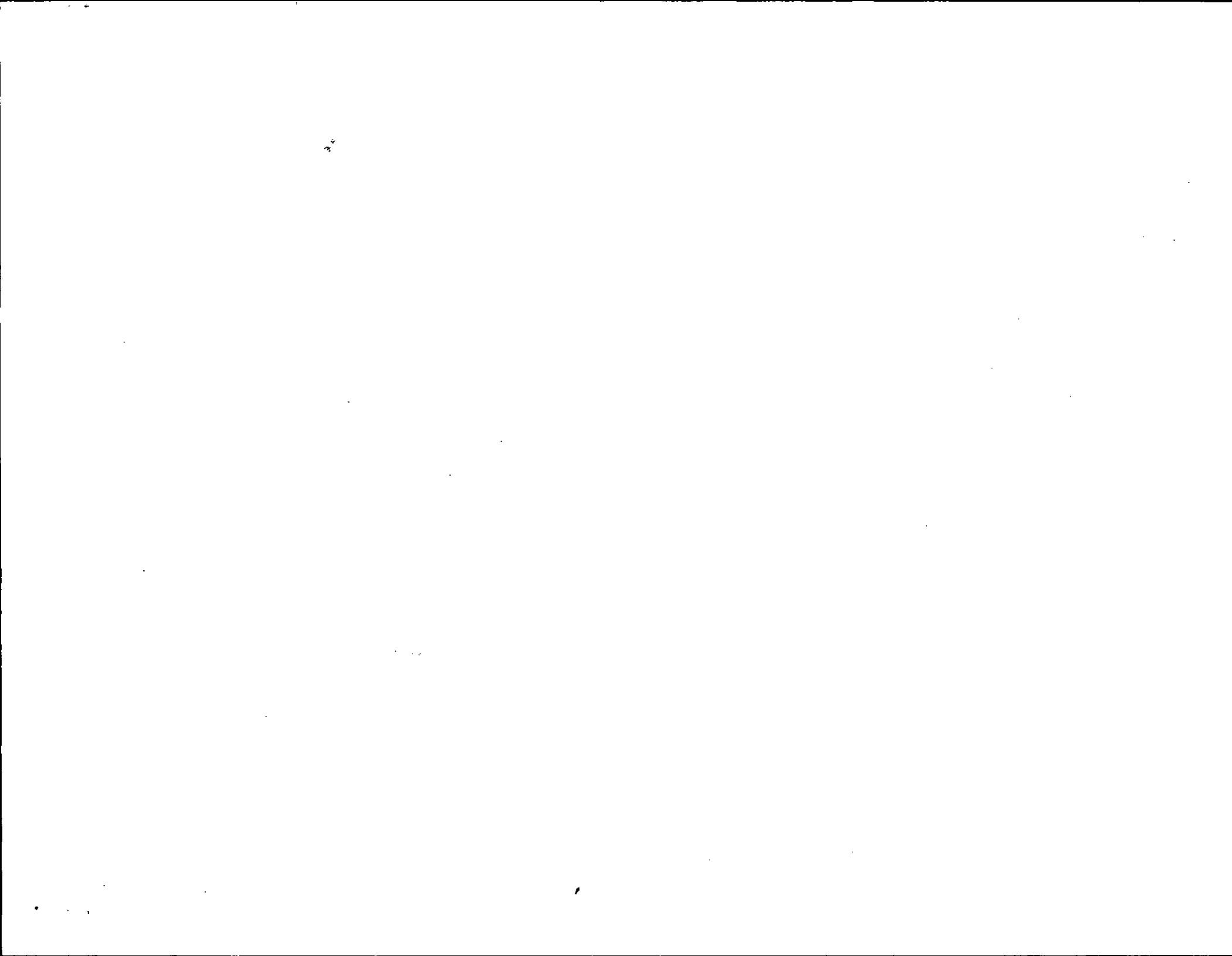
DART AEROSPACE LTD	Work Order:	105890
Description: Angle	Part Number:	D3171-1
Inspection Dwg: D3171	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	Jm	Audited by:	S	Prototype Approval:	N/A
Date:	13-08-09	Date:	13-08-09	Date:	N/A

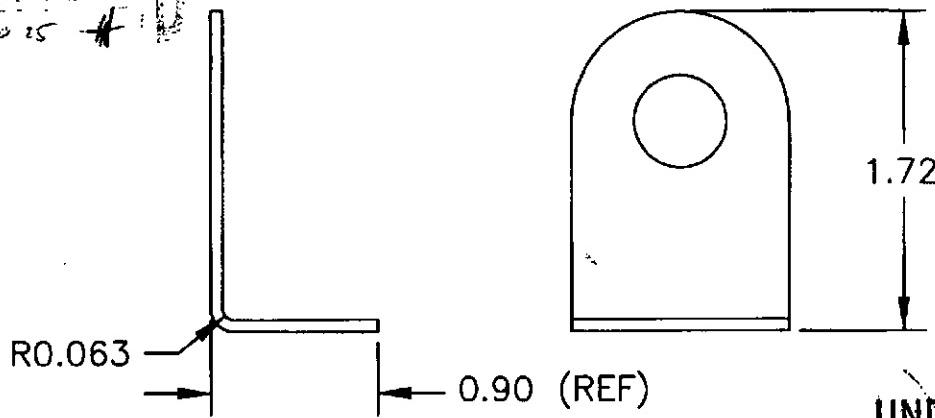
Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	



DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3171	SHEET 1 OF 1
DATE	TITLE	SCALE	1:1
02.10.08	ANGLE		
A	02.10.08	NEW ISSUE	

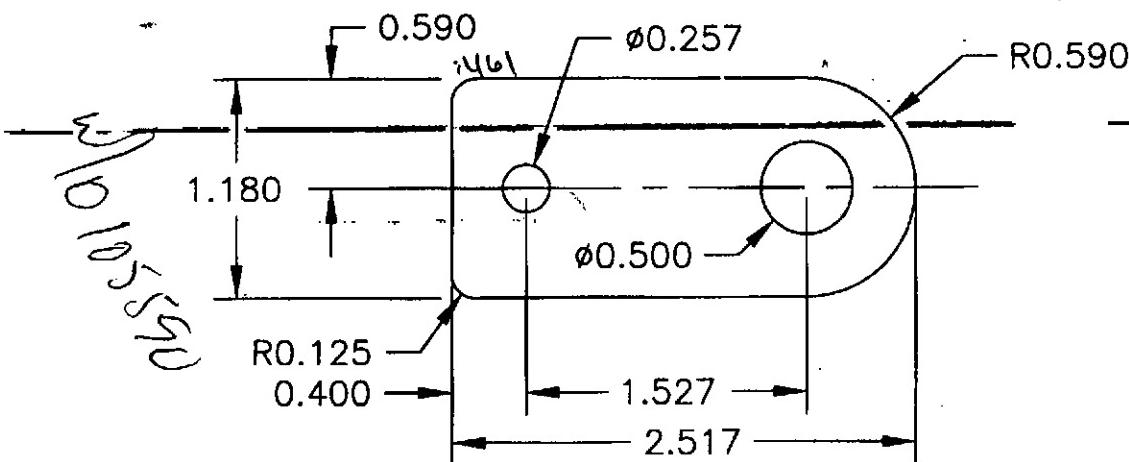
RELEASER
P 02.10.08

D3171-1 ANGLE**UNDER REVIEW**

OK
CB
3 not
being
used

17.01.02 CB

obj w -3

D3171-1 ANGLE FLAT PATTERNNOTES

- 1) MATERIAL: AISI 304/316 ANNEALED SS SHEET 0.063 THICK PER MIL-S-5019 (REF. DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

